

What is claimed is:

1. A method for making an insert, comprising the steps of:
 - a) injecting a starting material in flowable form comprising a medicant and a thermal setting material into a molding chamber having a shape;
 - 5 b) solidifying said starting material so as to form a solid insert having the shape of said molding chamber; and
 - c) ejecting said solid insert from said molding chamber,wherein said steps occur during rotation of said molding chambers about a central axis.
- 10 2. Product made by the process of claim 1.
3. The method according to claim 1, further comprising the steps of:
 - d) embedding said solid insert into a powder comprising a second medicant;
 - 15 and
 - e) compressing said powder around said insert.
4. The method according to claim 1, wherein said starting material is above room temperature when injected into said molding chamber, and wherein solidifying step (b) comprises cooling said mixture.
- 20 5. The method according to claim 1, wherein said molding chamber comprises a piston disposed therein, said piston being capable of displacement within said molding chamber, and wherein said method further comprises the step of adjusting the volume of said molding chamber by displacing said piston therein.
- 25 6. The method according to claim 5, ejecting step (c) is performed by displacing said piston within said molding chamber.
7. The method according to claim 1, wherein said injecting step (a) comprises placing a nozzle adjacent said molding chamber and delivering said starting material directly from said nozzle into said molding chamber.
- 30 8. An apparatus for molding substrates from a starting material in flowable form, comprising a plurality of molding chambers and a plurality of nozzles aligned with said

molding chambers, said molding chambers and said nozzles mounted on a rotor capable of rotation about a central axis, said nozzles being displaceable in a direction parallel to said central axis, such that as said rotor rotates, said nozzles engage and disengage said molding chambers.

9. The apparatus of claim 8 further comprising a heated reservoir for supplying said starting material to said nozzles, and wherein said molding chambers are cold.

10. The apparatus of claim 9 further comprising a plurality of valves each comprising a valve seat with a gasket therein, said valves being disposed in flow paths connecting the reservoir and the nozzles, said valve seat having the geometry of a gradually tapering hole, such that as said gasket closes starting material is sucked back from said nozzles.

11. A dosage form comprising a medicant, said dosage form prepared by molding a starting material in flowable form, said dosage form having no more than one axis symmetry and being substantially free visible defects.

12. The dosage form of claim 11, wherein said starting material comprises a thermal setting material.

13. A dosage form comprising an insert prepared by molding a starting material in flowable form embedded in a compressed dosage form, said compressed dosage form being at least partially coated with a thermal molded coating.